110

QC

QC2- Inspect parts off machine FAI/FAIB

2-Deburr if necessary

0.00

Memo

0.00

Quality Control

110

NCR: Y	es / No			WORK ORDER NON-C	CONFO	RM	IANCE / UPDATE					
									QA Closed:	Dat	e:	
Work Orde	r:			DISPOSITION			AGAII	NST DEI	PARTMENT	PROCESS		
Part N NCR N	0.			 Rework Scrap Use-as-is Work Order Update	Th	M ermo	Skid-tube Crossti Machining Small oforming Finish Large Fab Compo	Fab ning		Water Jet d. Eng. Coor. e/Packaging Supplier		ering ality ther
			1 1						Cian 0		 	
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance	Initia Chief E		Action Description		Sign & Date	Verification	n QC in	spector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
				 · · · · · · · · · · · · · · · · · · ·	AULT CA	ATEG	iORY					
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. It In Strip in I Bend Vaves in E	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Insp Instr Mai Misl Misr Offs	dward ruction inter labele read set of Ca	on Incomplete ons Incomplete/Unclear nance led alibration		Ovalized Over/Under Part Incorred Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/ Temperat Weld Wrong Sto	
	Turning S	equence		Finish	LJout	01.26	equence					

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97691 February-21-13 12:40:34 PM				*97691*								
Item ID: Revision ID: Item Name:	D3953-19 Gas Spring Br	racket		Accept	*N900	040	100)* s	etup Sta	1	JS1* JS2*	
	2/21/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item Customer:					•	V. 1/	
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:	_	R			J R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			St	^{ор} *Г	NR2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run He urs	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe		
120 *120*		QC8- Inspect parts - seco	nd check	0.00				12				
QC Quality Control		Мето		0.00 B3 A								
130				0.00				/d×			M	
130 Small Fab		Memo		0.00				10 X				
Small Fab			ER HOLE AS PER DWG									
		2- DEBURR	IF NECESSARY	2.4								
140		QC5- Inspect part comple	eteness to step on W/O	0.00				12				
140 QC		Memo		0.00 13-32	ı (104				

Quality Control

NCR: \	es / No				WORK ORDER NON-C	CONF	ORI	MANCE / UP	DATE	OA Clasadi	Date	· ·
						-1				QA Closed:	Date	2.
Work Orde	nr:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
WOIK OIGE	=1. 				Rework	7 		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	مار				Scrap	┪ ┃	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, ruici					Use-as-is	┥┃,		noforming	Finishing	-1	re/Packaging	Other
NCR N	۱o.				Work Order Update	1 1		Large Fab	Composite	1	Supplier	
					,							
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup							, 1					,
Other												
Process			· :									
Supplier												
Training												
Unapproved	<u>.</u>	<u> </u>								<u> </u>	<u> </u>	
			<u> </u>			AULT (CATE	GORY		<u></u>		
Landii	ng Gear				General				[ن د د د	Г	Pressure/Forced
	Bending			\ \-	Bend	-	rain		<u> </u> -	Ovalized Over/Under		Temperature/Cure
		ot Conce	ntric to (^{)/5} -	BOM/Route	\vdash	ardwa		-	Part Incorre	<u>-</u>	Weld
	Cracks	/C-:		-	Broken/Damaged	—	-	ion Incomplete	Lineleer –	Part Incorre	-	Wrong Stock Pulled
	Cuffs	/Crimped	-	\vdash	Burrs Contamination	\vdash		tions Incomplete/	Unclear	Part Moved	· L	Wrong stock Fulled
	Heat Tre	a t			Countersink	\vdash	islabe		<u> </u>	Positioned \		
	 1	at on Strip in	Tubo	-	Cut Too Short		isread		-	Power Loss		Other
	Ripples in		TUDE		Drill Holes	—	ffset	4	L	J' 0 We' 1033/	24,80	Total Control
		Vaves in E	Extrusion	, 	Drawing	\vdash		Calibration				
		Sequence		` ⊢	Finish	\vdash		Sequence			- Company of the Comp	
ì	1101111115	requence		- 1	1	<u>ا</u> ب						

DQA:

Date:

Wave/Twist in Tube

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Work Ord February-21-13				*976	391*							Page 3
Item ID: Revision ID: Item Name:	D3953-19 Gas Spring I	Bracket		Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date Reference:	2/21/13 : 3/08/13	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12		Cust Item I Customer:	D:						
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 150 *150* Packaging	ID	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Pian Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00							<u>3/3/</u> M	25 D N N 13-3-2

NCR: Y	'es / No				WORK ORDER NON-	CONF	ORN	MANCE / UPI	DATE			
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	 	 		·	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap		ľ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is] Т	herm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update] [Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	_											
Material												
Setup		1										
Other							j					
Process	_											
Supplier	_											
Training												
Unapproved												
						AULT (CATE	GORY				
Landir	ng Gear				General		:			Ovalized	Γ	Pressure/Forced
	Bending			\(\begin{array}{c} - arr	Bend	⊢	rain ardwa		\vdash	Over/Under	talaranaa 📙	Temperature/Cure
}	Centre No	ot Concer	ntric to C	" ³ -	BOM/Route Broken/Damaged	⊢		ire ion Incomplete		Part Incorre		Weld
	Cracks Crushed/	Crimpod		\vdash	Burrs	\vdash		ion incomplete/lions Incomplete/l	Unclose	Part Lost/Mi	-	Wrong Stock Pulled
}	Cuffs	сппреи.		-	Contamination	-		nance	Officieal	Part Moved	1331118	Twiong stock ranea
•	Heat Trea	h+		-	Countersink	\vdash	islabe			Positioned V	Mrong	
}	Inspection		Tube	-	Cut Too Short		isread		-	Power Loss/		Other
}	Ripples in		TUDE		Drill Holes		fset	•	<u>L</u>	J. 0 c. 2033/		123
}	Torque W		xtrusion	, H	Drawing	\mathbf{H}		Calibration				
}	Turning S			·	Finish	\vdash		Sequence				
i	1	- 4		ı	1	<u>ا</u> س						

DQA: Date: ___

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

February-21-13 12:40:34 PM

Work Order ID:

97691

Parent Item:

D3953-19

Parent Item Name:

Gas Spring Bracket

Start Date: 2/21/13

Required Date: 3/08/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC verified by:EC

IPP Rev:B as per dwg revC DD 10.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	266.5500	0.018	0.2273688	_ s	113.	03:15
				Location		Loc Qty	Lo	c Code					
				MAT020		266.55							
				12252 24445	21	74.55							
				24445	<u>;</u>	192							

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	RMANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT		7 [7
Part N				 -	Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root					ption of work order update	Initial	1	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data										1	
Equip/Tooling						į					
Operator											
Material											
Setup										İ	
Other											
Process			·								
Supplier	_					ļ					
Training	_										
Unapproved		<u> </u>	<u> </u>		<u>v</u>	<u> </u>		· _ · · · ·	<u></u>	<u> </u>	<u> </u>
			 			AULT CAT	EGORY				
Landir F	ng Gear			_	General 🤃	<u></u> .			٦		٦,
}	Bending			_	Bend	Grain		-	Ovalized		Pressure/Forced
}	Centre No	ot Concei	ntric to	O/S -	BOM/Route	Hardy			Over/Under	 	Temperature/Cure
}	Cracks	o			Broken/Damaged	—	ction Incomplete	/··	Part Incorre	⊢	Weld
1	Crushed/	Crimpea.		-	Burrs		ictions Incomplete/ itenance	Unclear	Part Lost/M Part Moved	· · · · · · · · · · · · · · · · · · ·	Wrong Stock Pulled
ŀ	Cuffs			.	Contamination Countersink	Misla		<u> </u>	Positioned \		
}	Heat Trea		Tubo	-	Cut Too Short	Misre		<u> </u>	Power Loss/		Other
}	Inspectio		rube	-	Drill Holes	Offse		<u></u>	Jrowei Loss/	onige	Tottlei
}	Ripples in			_	-		ι f Calibration				
}	Torque W			-	Drawing	\vdash	f Sequence				
1	Turning S	equence		ł	Finish	I lourg	i sequence				

DQA:

Date:

Wave/Twist in Tube

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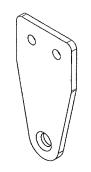
DART AEROSPACE LTD	Work Order:	97691
Description: Gas Spring Bracket	Part Number:	D3953-19
Inspection Dwg: D3953 Rev: C		Page 1 of 1

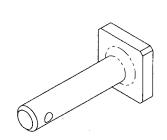
FIRST ARTICLE INSPECTION CHECKLIST

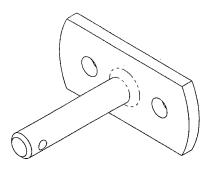
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.193	V		Ver	MM-01
Ø0.257	+0.006/-0.001	0.256	V		Ven	
0.38	+/-0.030	0.38	/		vers	
1.38	+/-0.030	1.387	/		veen	
0.625	+/-0.010	0.625	/		perd	
0.375	+/-0.010	0.38	/		JANN	
1.00	+/-0.030	1.00	V		ven	
1.500	+/-0.010	1.503	V		ven	
1.88	+/-0.030	1.881			vern	
0.125	+/-0.010					
		·				
			cAs			

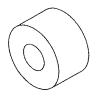
Measured by:	whit	Audited by:	2 3 9	Preliminary Approval:	
Date:	13.03.15	Date:	1> >1	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.03.31	New Issue	KJ ,	
В	11.01.17	Dimensions revised	KJ %	N/











D3953-1 GAS SPRING BRACKET (FULL LID)

D3953-3 GAS SPRING STUD, LID

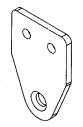
D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER











D3953-11 GAS SPRING SPACER

8

 $\frac{\text{D3953-13 GAS SPRING SPACER}}{\text{(FULL LID)}}$

D3953-15 GAS SPRING BRACKET (SPLIT LID)

D3953-17 GAS SPRING SPACER (SPLIT LID)

D3953-19 GAS SPRING BRACKET (SQUARE BASKET) <u> </u>

S. O. i CTPRSTO CHARMENCO * NCONTROLLED COPY SUBJECT TO A MENDMENT STHEAT NOTICE WO SCORDER



13-02-21 D3953-21 GAS SPRING BRACKET (SQUARE BASKET)

DESIG	N AJS	DART AEROSPA	ACE LI	TD .
REV.		ESCRIPTION	BY	DATE
A	NEW ISSUE		AJS	09.07.27
В	I DIMENSIONS MIN/MAX F	0.05 MIN WAS 0.13, MULTIPLE REMOVED TOLERANCE ADDED. ISTALLING COTTER PIN AT NEXT	AJS	09.11.11
С	PARTS -19 & -21 ADDED CHAM (C6-2, B6-3, C6-4) (C7-2, C7-4); SECTION C REASON: ADDL PARTS I	(SHT 1& 4); CSK CALLOUT WAS ; & SYMM WAS & SYM ABOUT -C REPOSITIONED TO 82-4 REQD; DRAFTING ERRORS	ЈРН	10.01.29

REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	- G	DRAWING NO.		REV. C
MFG. APPR.	E.	D3953	SHEET 1 OF 4	
APPROVED	-A-	TITLE		SCALE
DE APPR.	#	GAS SPRING LID COMPO	ONENT	S NTS
DATE 10.01.29		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOUNTAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		

